

In the Claims

1. (Currently Amended) A method for the manufacture of an electric motor for a hard disk drive comprising a stator (15), a rotor (11), a shaft (35) and a hydrodynamic bearing arrangement (13) which rotatably supports the rotor (11) with respect to the stator (15), wherein
 - a) a bearing sleeve (37) of the hydrodynamic bearing arrangement (13) is manufactured including a groove pattern on at least one bearing surface (38);
 - b) an axial ring (47) is fixed to one end of the shaft (35);
 - c) the shaft (35) is inserted together with the axial ring (47) into bearing sleeve (37);
 - d) one end of the bearing sleeve (37) is sealed with a counter disk (41);
 - e) bearing fluid is inserted into a bearing gap between the shaft (35) and the bearing sleeve (37); ~~and~~
 - f) the shaft (49) is connected to a rotating component (11) of the electric motor; and
 - g) ~~the assembly (49) consisting of~~ comprising the shaft (35), ~~and~~ the bearing arrangement (13) and the rotating component (11) is tested before it is ~~in-~~ stalled adhesively bonded to in the spindle base plate (21) of the electric motor.

2-4. (Cancelled) .

5. (Currently Amended) A method according to claim ~~[[4]]~~1, wherein an adhesive with low gas emission properties is used.

6. (Currently Amended) A method according to claim 1 wherein during manufacture of the bearing sleeve (37), the inner bearing surface (38) of the bearing sleeve (37) is provided with a said groove pattern (40).
7. (Currently Amended) A method according to claim 1 wherein a transition fit is provided ~~at a fixed assembly section~~ between the bearing arrangement (13) and the ~~stator (15) or the rotor (11)~~ base plate(21).
8. (Cancelled).
9. (Original) A method according to claim 1 wherein a hub (31) of the rotor (11) is fixedly connected to the shaft (35), with a unit consisting of rotor hub (31), shaft (35) and bearing sleeve (37) then being mounted with respect to the stator (15).
10. (Currently Amended) A spindle motor for a hard disk drive comprising a rotor (11), a stator (15), a shaft (35) and a hydrodynamic bearing arrangement (13) that rotatably supports the rotor (11) with respect to the stator (15), the hydrodynamic bearing arrangement having a bearing sleeve (37) on whose inner surface (38) a groove pattern (40) is formed in order to create a hydrodynamic radial bearing, an axial ring (47) being mounted onto the shaft (35) to create a hydrodynamic axial bearing, the shaft (35) being inserted into the bearing sleeve (37), one end of the bearing sleeve (37) being sealed with a counter disk (41), bearing fluid being inserted into the bearing gap between the shaft (35) and the bearing sleeve (37), and the rotor (11) being connected to the shaft (35), wherein the hydrodynamic bearing rotor assembly arrangement (13) thus produced forming a fully functional unit that can be tested before being ~~mounted onto the rotor (11) or the stator (15)~~

~~of the spindle motor~~ adhesively bonded to the base plate (21) of the spindle motor.

11-12. (Cancelled).

13. (Currently Amended) A spindle motor according to claim 10 wherein a transition fit is provided between the bearing-rotor assembly (49) ~~arrangement (13)~~ and the base plate (21) ~~stator (15) or the rotor (11)~~.

14. (Cancelled).

15. (Currently Amended) A spindle motor according to claim 10[[14]], wherein a groove (55) is provided on at least one of the bonded contact surfaces of either the bearing-rotor assembly (49) ~~arrangement (13)~~ or the base plate (21) ~~stator (15) or the rotor (11)~~.

16. (Original) A hard disk drive having a spindle motor according to claim 10.

17. (Currently Amended) A hydrodynamic bearing rotor assembly ~~arrangement~~ for an electric motor comprising a stator (15), a rotor (11), a shaft (35) and the hydrodynamic bearing arrangement (13), which rotatably supports the rotor with respect to the stator, the hydrodynamic bearing arrangement (13) having a bearing sleeve (37), an axial ring (47) being mounted onto one end of the shaft (35) and the shaft (35) being inserted into the bearing sleeve (37); the corresponding end of the bearing sleeve (37) being sealed with a counter disk (41); bearing fluid being inserted into the bearing gap between the

shaft (35) and the bearing sleeve (37), wherein the shaft (35) is inserted into the bearing sleeve (37) and the rotor (11) is connected to the shaft (35), wherein the bearing-rotor assembly (49) thus produced forms a fully functional unit that can be tested before being adhesively bonded to a base plate of the spindle.